

Date: Monday, 02/02/2009 11:49:47 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: JACK SADDLE		
Job Number	: 45383			Part Number	: D2281		
Estimate Number	: 11177			Drawing Number	: D2281 REV G		
P.O. Number	:			Project Number	: N/A		
This Issue	02/02/2009	S.O. No.	:	Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	1 /	Type	SMALL /MED FAB	Due Date	03/03/2009	Qty:	100
Previous Run	: 44442			Um:	Each		
Written By	:						
Checked & Approved By	: <u>SL 009-02-02</u>						
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM						
	Est: rev B 06.07.17 waterjetEC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS sheet.080  <i>CUT OF MAT</i>
Comment:	Qty.: 0.1313 sf(s)/Unit	Total : 13.1250 sf(s)
	304SS .080	<i>109358 HB 9-2-22</i>
	batch:	
2.0	WATER JET	FLOW WATER JET
Comment:	FLOW WATER JET	
1-Cut as per Dwg D2281		
Dwg Rev: <u>G</u>		
Prog Rev: <u>G</u>	<i>HB 9-2-22</i>	
2-Deburr if necessary	<i>HB 9-2-22</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <i>HB 9-2-22</i>
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
Comment:	SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  <i>S 09/09/23 x82</i>
Comment:	Deburr	
		<i>145</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: JACK SADDLE

Job Number: 45383

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

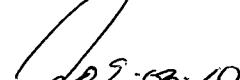
SP 09/03/10

92

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location MISC

92

SP 09.03-10.

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>NS383</b>
<b>Description:</b> Jack Saddle	<b>Part Number:</b>	<b>D2281</b>
<b>Inspection Dwg:</b> D2281	<b>Rev:</b> G	<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	13	Audited by:	✓	Prototype Approval:	N/A
Date:	9-2-22	Date:	09/09/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	GL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

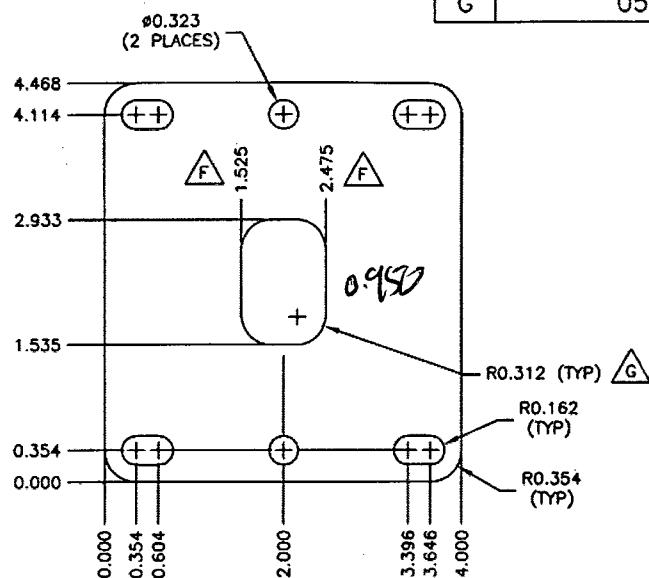
NOTE: Date & initial all entries

**DART**

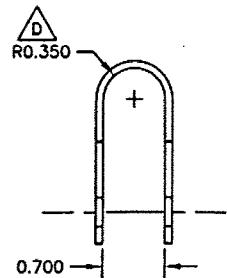
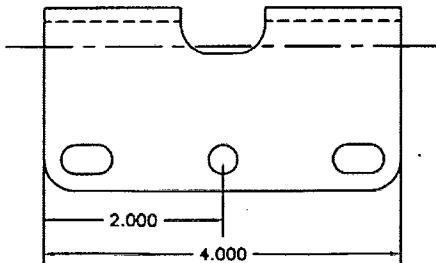
DESIGN BW	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>WMS</i>	DRAWING NO. D2281 REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2

**RELEASED**

05/08/11



FLAT LAYOUT



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. W5385D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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